

Work Order ID 55084

January 5, 2010 3:05:03 PM



Page 1

Item ID: D4038-9

Accept



Setup Start



Revision ID:

Item Name: Aft Block, Fwd, LH

Stop



Start Date: 05/01/2010 Start Qty: 1.00

Required Date: 15/01/2010 Req'd Qty: 1.00

Cust Item ID:

Customer:

Reference:

10-01-10

Approvals:

Process Plan:

Date:

Tooling:

Date:

Run Start



QC:

Date:

SPC (Y/N):

Date:

Stop



Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Draw Number	Draw Rev.	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
Draw Nbr	Revision Nbr								
D4038	A-PRELIM								

100



Mill Conv

Memo

0.00

Conventional Milling Machine

Mill as per Dwg

0.00

MWF
10/01/07

1 0

110



QC

QC2-Inspect parts off machine FAI/FAIB

Memo

0.00

MWF
10/01/07

1 0

Quality Control

120



QC

QC8- Inspect parts - second check

Memo

0.00

OK 10/07/07

1 0

Quality Control

PRELIMINARY ISSUE

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Work Order ID 55084

January 5, 2010 3:05:03 PM



Page 2

Item ID: D4038-9

Accept



Setup Start



Revision ID:

Stop



Item Name: Aft Block, Fwd, LH

Start Date: 05/01/2010 Start Qty: 1.00

Cust Item ID:

Required Date: 15/01/2010 Req'd Qty: 1.00

Customer:

Reference:

Run Start



Approvals:

Process Plan:

Date:

Tooling:

Date:

Stop



QC:

Date:

SPC (Y/N):

Date:

Sequence ID/
Work Center IDOperation
DescriptionSet Up/
Run HoursDraw
NumberDraw
Rev.Plan
CodeAccept
QtyReject
QtyReject
NumberInsp.
Stamp

130

Chemical Conversion Coat per QSI005 4.1

0.00

BR 10-01-7

①



HandFinish

Memo

0.00

Hand Finishing

150

QC3- Inspect Part Finish

0.00

MJ 10-01-07

(X1) 0



QC

Memo

0.00

Quality Control

160

Identify as per dwg & Stock Location: David S

0.00

Czlgary

u

10-01-07



Packaging

Memo

0.00

Packaging

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Work Order ID 55084

Page 3

January 5, 2010 3:05:04 PM

Item ID: D4038-9

Accept



Setup Start



Revision ID:

Stop



Item Name: Aft Block, Fwd, LH

Start Date: 05/01/2010 Start Qty: 1.00

Cust Item ID:

Required Date: 15/01/2010 Req'd Qty: 1.00

Customer:

Reference:

Run Start



Approvals:

Process Plan:

Date:

Tooling:

Date:

Stop



QC:

Date:

SPC (Y/N):

Date:

Sequence ID/
Work Center IDOperation
DescriptionSet Up/
Run HoursDraw
NumberDraw
Rev.Plan
CodeAccept
QtyReject
QtyReject
NumberInsp.
Stamp

170

QC21- Final Inspection - Work Order Release

0.00



QC

Memo

0.00

Quality Control

0329 JAN 11 10-1-05
①

POSITIVE RECALL

EFFECTIVE 12/26/06 AUTH W

RELEASED _____ DATE _____

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Picklist Print

January 5, 2010 3:05:08 PM

Page 1

Work Order ID: 55084



Parent Item: D4038-9



Parent Item Name: Aft Block, Fwd, LH

Start Date: 05/01/2010

Required Date: 15/01/2010

Comments: Ipp Rev:A New Issue 09-12-14 JLM Verified By:EC

Start Qty: 1.00

Required Qty: 1.00

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Remaining Qty To Pick	Qty Issued	Date Issued	Status
M6061T6B1.500X02.00 0		Purchased		No			f	16.5683	0.1747			



6061-T6 Bar 1.50 x 2.00

<u>Warehouse</u>	<u>Loc Qty</u>	<u>Loc Code</u>
<u>Location</u>		
Main Warehouse		
MAT	16.5683	
108877	0.4736	
110167	16.0947	

0.1747 DJT
10/01/06

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

DART AEROSPACE LTD		Work Order:	55084
Description: <u>Alt Block, Fwd, LH</u>		Part Number:	D4038-9
Inspection Dwg: D4038 Rev: A-PRELIM		Page 1 of 1	

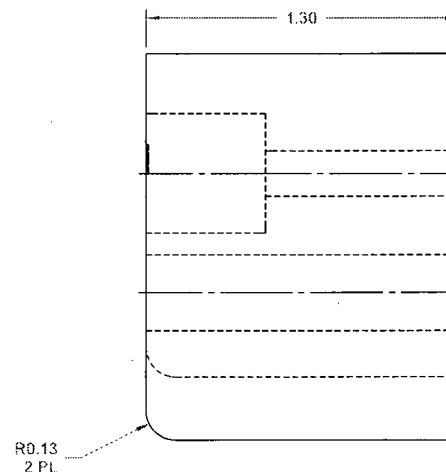
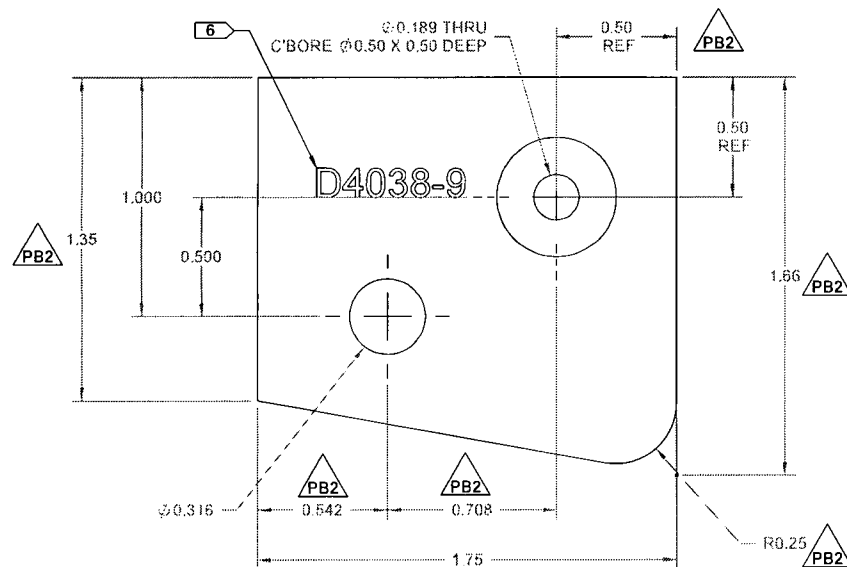
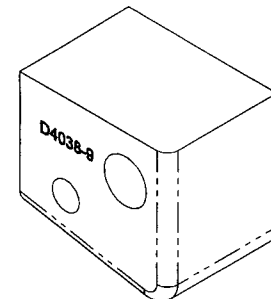
FIRST ARTICLE INSPECTION CHECKLIST

☒ First Article ☐ Prototype

Drawing Dimension	Tolerance	Actual Dimension	Accept	Reject	Method of Inspection	Comments
1.75	±.03	1.75	✓			
1.66	±.03	1.65	✓			
1.35	±.03	1.35	✓			
1.30	±.03	1.29	✓			
1.000	±.010	.998	✓			
.500	±.050	.500	✓			
.542	±.010	.539	✓			
1.250	±.010	1.247	✓			
Ø .316	+.006/-0.001	Ø .320	✓			
Ø .189	+.005/-0.001	Ø .191	✓			
C Bore Ø .500	+.006/-0.001	Ø .499	✓			
" .500 deep	±.010	.498	✓			
R .13	±.03	R .125	✓			

Measured by: <u>MW</u>	Audited by: <u>ML</u>	Prototype Approval:	N/A
Date: <u>10/01/07</u>	Date: <u>10/01/07</u>	Date:	N/A

Rev	Date	Change	Revised by	Approved
A		New Issue	KJ/JLM	



D4038-9 BLOCK

55084

NOTES:

- 1) MATERIAL: 6061-T6 (OR 6061-T651/T6510/T6511/T62) ALUMINUM BAR
PER AMS-QQ-A-225/8 (OR AMS 4117/4128/4115/4116)
PER AMS-QQ-A-200/8 (OR AMS 4160)
REF DART SPEC M6061T6B
- 2) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: ENGRAVE P/N IN THIS AREA AS SHOWN TO MAX DEPTH
OF 0.010 IN 0.12 HIGH LETTERS WITH MIN RADIUS TOOL OF 0.015
- 7) WEIGHT: 0.31 lbs

PRELIMINARY ISSUE

10.01.05

DESIGN		DART AEROSPACE LTD	
DRAWN		HAWKESBURY, ONTARIO, CANADA	
CHECKED		DRAWING NO.	REV. PB2
MFG. APPR.		D4038	SHEET 11 OF 14
APPROVED		TITLE	SCALE
DE APPR.		BRACKET	NTS
DATE	10.01.05	<small>COPYRIGHT © 2009 BY DART AEROSPACE LTD THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIES OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD.</small>	